



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2572
Job Sheet 172062



Part No: D2572 **Job Qty:** 12 ea
Part Name: Saddle, Fwd, In
Part Weight: 0 lbs **Status:** Scheduled **Priority:** Medium
Job Created: 2/12/18 **Job Tracking No:**
Due Date: 2/19/18 **Created By:** Michelle Gagnon-Donovan
Type: Stock **Description:**
Note: DWG REV F IPP: I 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	2/16/18	2/16/18	0.00	0.00	Start Up Machining		53L 18/02/19
100	CNC Vertical Machining	12 pcs	2/17/18	2/17/18	0.62	19.35	HAAS 1		18/02/19
110	Mill Conv	12 pcs	2/17/18	2/17/18	0.00	2.00	Mill Conv 1		18/02/19
120	QC	12 pcs	2/17/18	2/17/18	0.00	0.00	QC2		18/02/19
130	QC	12 pcs	2/17/18	2/17/18	0.00	0.00	QC8		18/02/19
140	HandFinish	12 pcs	2/17/18	2/17/18	0.00	0.49	HandFinish1		18-02-28
150	Powdercoat	12 pcs	2/19/18	2/19/18	0.00	0.46	Powdercoat1		18-02-28
160	QC	12 pcs	2/19/18	2/19/18	0.00	0.00	QC3		MAR 01 2018
170	Packaging	12 pcs	2/19/18	2/19/18	0.00	0.00	Packaging3		0-89
180	QC21-SA	12 Ea	2/19/18	2/19/18	0.00	0.00	QC21		MAR 02 2018

Part Op 100 - Program Batch No. 5043561 Double check by: H.A. 1-Machine Step No 1 per Folio FA051 and inspect per
Descriptions: attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and insp
110 - Machine keyway as per dwg D2571 & D2572
150 - START TIME: 3:25 FINISH TIME: 3:55 A.T. 320° 17138467.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-005	Saddle Billet	12 Ea (1 ea)	90-Start up Operation	5043561
5X F165017 + 7X S038651				

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-005	12	65	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Fwd Inboard	0.438Inches + 0.005 - 0.000	0.443 0.438		
2	Saddle, Fwd Inboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
3	Saddle, Fwd Inboard	3.495Inches + 0.010 - 0.000	3.505 3.495		
4	Saddle, Fwd Inboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
5	Saddle, Fwd Inboard	7.990Inches + 0.020 - 0.000	8.010 7.990		



Container No: S043561



Part: D2572

Job No: 172062

Serial No/Batch: S043561

Revision: D2572

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/19/18

6	Saddle, Fwd Inboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
7	Saddle, Fwd Inboard	0.257Inches	+ 0.005 - 0.000	0.262 0.257
8	Saddle, Fwd Inboard	0.375Inches	+ 0.005 - 0.000	0.380 0.375
9	Saddle, Fwd Inboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
10	Saddle, Fwd Inboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
11	Saddle, Fwd Inboard	0.558Inches	+ 0.020 - 0.000	0.578 0.558
12	Saddle, Fwd Inboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
13	Saddle, Fwd Inboard	1.490Inches	+ 0.010 - 0.000	1.500 1.490
14	Saddle, Fwd Inboard	2.495Inches	+ 0.010 - 0.000	2.505 2.495
15	Saddle, Fwd Inboard	3.869Inches	+ 0.010 - 0.000	3.879 3.869
16	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
17	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
18	Saddle, Fwd Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
19	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
20	Saddle, Fwd Inboard	0.178Inches	+ 0.020 - 0.000	0.198 0.178
21	Saddle, Fwd Inboard	2.940Inches	+ 0.040 - 0.000	2.980 2.940
22	Saddle, Fwd Inboard	0.230Inches	+ 0.020 - 0.000	0.250 0.230
23	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
24	Saddle, Fwd Inboard	0.307Inches	+ 0.005 - 0.000	0.312 0.307
25	Saddle, Fwd Inboard	0.760Inches	+ 0.005 - 0.000	0.765 0.760
26	Saddle, Fwd Inboard	0.352Inches	+ 0.020 - 0.000	0.372 0.352
27	Saddle, Fwd Inboard	0.470Inches	+ 0.060 - 0.000	0.530 0.470
28	Saddle, Fwd Inboard	0.615Inches	+ 0.020 - 0.000	0.635 0.615
29	Saddle, Fwd Inboard	0.053Inches	+ 0.020 - 0.000	0.073 0.053
30	Saddle, Fwd Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
31	Saddle, Fwd Inboard	1.375Inches	+ 0.020 - 0.000	1.395 1.375
32	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
33	Saddle, Fwd Inboard	0.240Inches	+ 0.040 - 0.000	0.280 0.240
34	Saddle, Fwd Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
35	Saddle, Fwd Inboard	2.000Inches	+ 0.020 - 0.000	2.020 2.000
36	Saddle, Fwd Inboard	0.023Inches	+ 0.020 - 0.000	0.043 0.023

Plex 2/12/18 12:55 PM Dart.Gagnon.Michelle

DART AEROSPACE LTD	Work Order: 172062
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		0.502	0.498	0.498	0.499		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.376	0.376	0.376	0.376		
I	0.490	0.510		0.505	0.500	0.500	0.498		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.570	0.569	0.569	0.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		0.131	0.130	0.130	0.130		
Q	0.115	0.135		0.130	0.126	0.125	0.125		
R	0.240	0.260		0.255	0.254	0.253	0.253		
S	0.115	0.135		0.131	0.126	0.128	0.127		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.240	0.243	0.243	0.242		
W	0.115	0.135		0.123	0.125	0.125	0.130		
X	0.307	0.312		0.307	0.312	0.311	0.311		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.362	0.363	0.363	0.363		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.622	0.622	0.622	0.622		
AC	0.053	0.073		0.061	0.061	0.061	0.061		
AD	0.240	0.260		0.250	0.251	0.251	0.252		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		0.128	0.128	0.128	0.128		
AG	0.240	0.280		0.240	0.240	0.240	0.240		
AH	0.240	0.260		0.251	0.252	0.252	0.251		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: SBL 19m
Date: 18/02/22

Audited by: [Signature]
Date: 18/02/25

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 172062
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	26	37	48		
A	0.438	0.443		438	438	438	438		
B	1.745	1.755		1,750	1,750	1,750	1,750		
C	3.495	3.505		3,500	3,500	3,500	3,500		
D	1.745	1.755		1,750	1,750	1,750	1,750		
E	7.990	8.010		8,000	8,000	8,000	8,000		
F	0.490	0.510		498	498	498	0,502		
G	0.257	0.262	258	258	258	258	258		
H	0.375	0.380	370	376	376	376	376		
I	0.490	0.510		500	500	500	500		
J	1.174	1.184	1,179	1,179	1,179	1,179	1,179		
K	0.558	0.578		569	569	569	569		
L	1.174	1.184		1,179	1,179	1,179	1,179		
M	1.490	1.500		1,495	1,495	1,495	1,495		
N	2.495	2.505		2,500	2,500	2,500	2,500		
O	3.869	3.879		3,874	3,874	3,874	3,875		
P	0.115	0.135		130	130	130	130		
Q	0.115	0.135		126	125	126	125		
R	0.240	0.260		255	250	253	254		
S	0.115	0.135		130	128	127	127		
T	0.178	0.198		188	188	188	188		
U	2.940	2.980		2,960	2,960	2,960	2,960		
V	0.230	0.250		240	241	241	242		
W	0.115	0.135		127	126	130	130		
X	0.307	0.312		311	311	311	312		
Y	0.760	0.765		760	760	760	760		
Z	0.352	0.372		363	363	363	363		
AA	0.470	0.530		500	500	500	500		
AB	0.615	0.635		626	626	626	621		
AC	0.053	0.073		070	070	068	070		
AD	0.240	0.260		250	251	252	252		
AE	1.375	1.395		1,385	1,385	1,385	1,385		
AF	0.115	0.135		125	127	129	125		
AG	0.240	0.280		250	250	250	250		
AH	0.240	0.260		252	252	250	252		
AI	2.000	2.020		2,000	2,000	2,000	2,000		
AJ	0.023	0.043		033	033	033	033		

Accept/Reject

Measured by: SBC	Audited by: [Signature]
Date: 18/02/22	Date: 18/02/25

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
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DART AEROSPACE LTD	Work Order: 172062
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	#9	#10	#11	#12		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.488	3.500	3.500	3.500		
D	1.745	1.755		1.745	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.000	8.000	8.000		
F	0.490	0.510		0.505	0.505	0.498	0.496		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.375	0.375	0.376	0.376		
I	0.490	0.510		0.500	0.500	0.501	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.569	0.566	0.568	0.567		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		0.130	0.130	0.125	0.130		
Q	0.115	0.135		0.125	0.125	0.130	0.125		
R	0.240	0.260		0.253	0.253	0.253	0.253		
S	0.115	0.135		0.128	0.129	0.130	0.130		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.240	0.243	0.242	0.242		
W	0.115	0.135		0.128	0.131	0.131	0.131		
X	0.307	0.312		0.312	0.312	0.312	0.312		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.363	0.363	0.363	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.622	0.622	0.622	0.622		
AC	0.053	0.073		0.070	0.061	0.061	0.061		
AD	0.240	0.260		0.252	0.253	0.251	0.252		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		0.126	0.128	0.128	0.128		
AG	0.240	0.280		0.250	0.240	0.240	0.240		
AH	0.240	0.260		0.250	0.254	0.252	0.251		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: SBL
Date: 18/02/22

Audited by: mgmt
Date: 18/02/25

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